



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400228M
Job Sheet 201340



Part No: RBT400228M

Job Qty: 2 pcs

Part Name: Mast Nut PSE



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/1/19

Job Tracking No:

Due Date: 10/3/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBT400228M Rev B IPP Rev. A 19.07.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	10/3/19		0.00	0.20	Small Fab - 1		
							Small Fab - 2		ML
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	2 pcs	10/3/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		DAS 61 9-89
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	2 pcs	10/3/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S219541



Part: RBT400228M

Job No: 201340

Serial No/Batch: S219541

Revision: B

Inspector:

Exp Date:

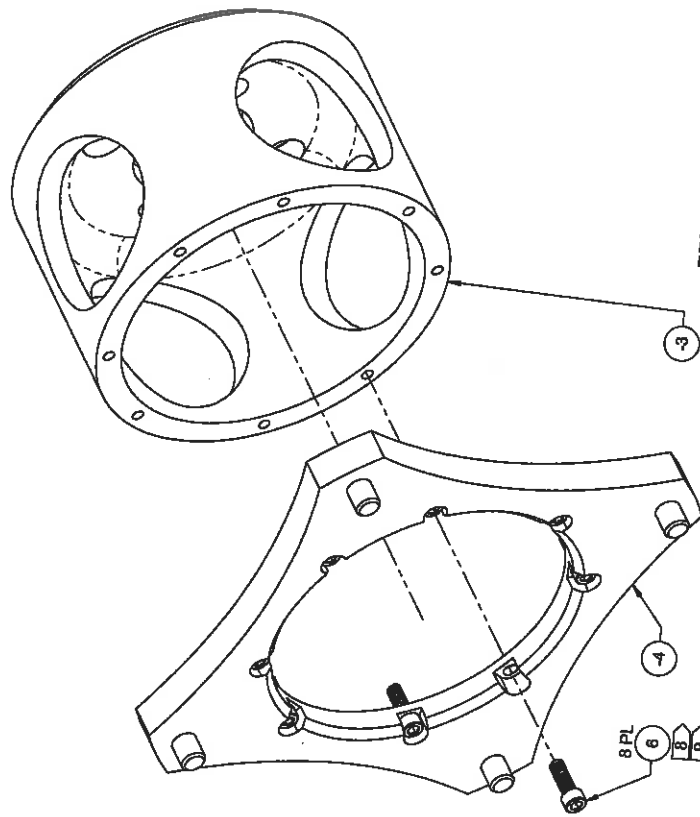
Instructions:

Date: 10/03/19

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	10/3/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53
Part Op 110 - (Small Fab) Assemble as per drawing. See note 8 and 9. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
90128A245	Steel Zinc Plated Socket Head Screw 1/4"-20 X 3/4" Long	16 Ea (8 ea)	110-Small Fab - 1	5211721	
RBT400228M-3	Cylinder	2 pcs (1 ea)	110-Small Fab - 1	5204186	
RBT400228M-4	Plate Assembly	2 pcs (1 ea)	110-Small Fab - 1	529411	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	90128A245	16	50	0	
	RBT400228M-3	2	4	0	
	RBT400228M-4	2	0	0	
Part Specifications					
Specifications could not be found.					

GA
TRD

ITEM #	QTY	PART #	PART TITLE
-3	1	RBT400228M-3	CYLINDER
-4	1	RBT400228M-4	PLATE ASSY
6	8	McMaster#901284245 OR EQUIV	STEEL ZINC PLATED SOCKET HEAD SCREW 1/4"-20 X 3/4" LG.

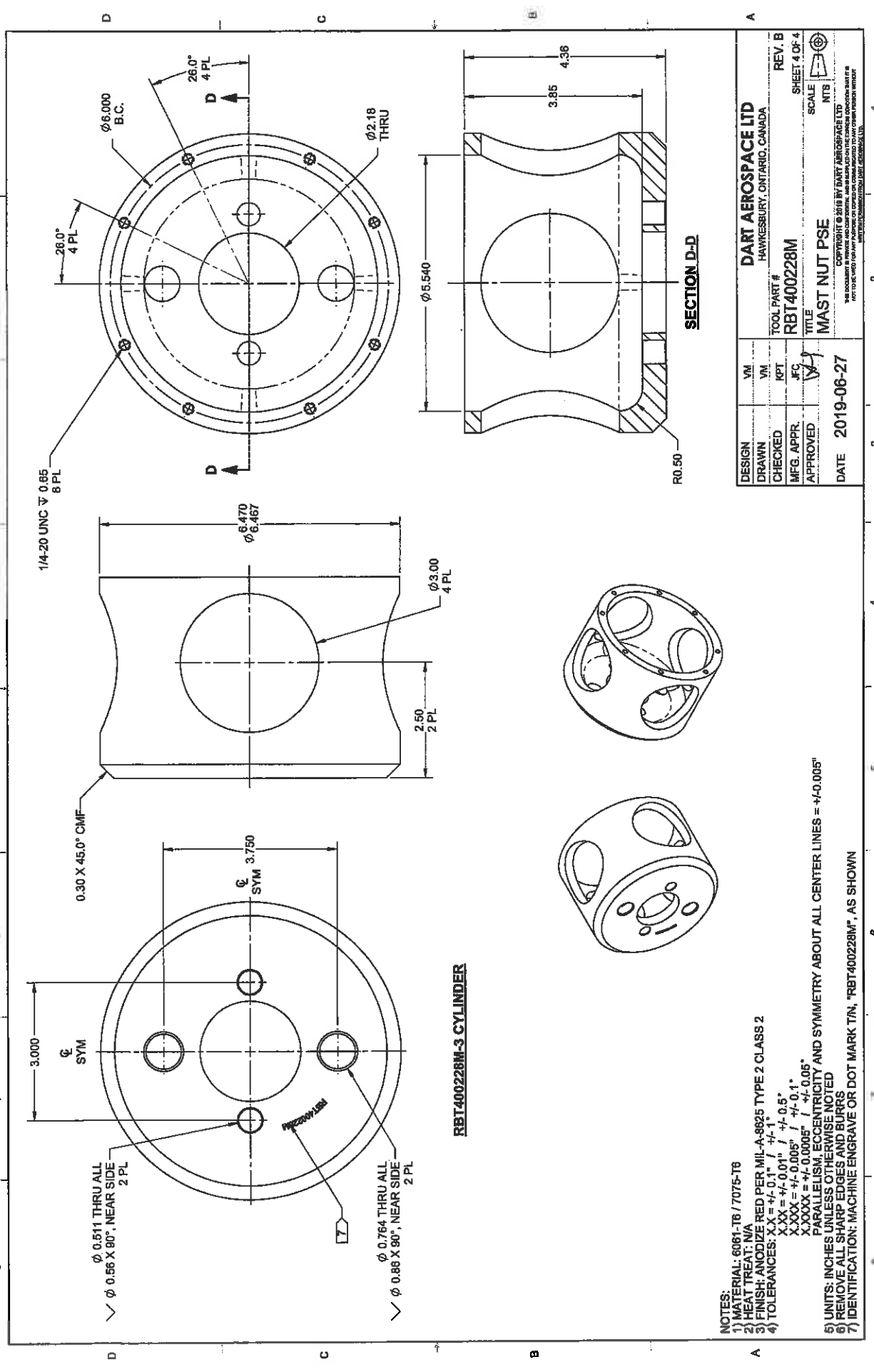


RBT400228M MAST NUT PSE

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLY AS SHOWN
 - 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 6 THEN ASSEMBLE WITH ITEM -3, AND REMOVE EXCESS
 - 9) TORQUE ITEM 6 TO 12.5 FT-LBS (150 IN-LBS)
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

REV.	DESCRIPTION	VM	BY
B	SEE PREVIOUS PDF FOR OLDER REV ITEM -4 WAS UPDATED PER DART HBY STANDARDS ITEM -5 WAS ADDED McMaster#901284245 ITEM -7 McMaster#903814680 CHANGED FOR ITEM 7 ITEM -8 McMaster#903814670 ITEM -9 DIMENSION 4X ϕ .4371/.4384 B.C ϕ .9189 CHANGED FOR CHANGED FOR 00.4370/.4384 PL 8.65 $\pm 0.001"$ MATERIAL 6061-T6 FOR SLOT ϕ 0.438, DIMENSION 1.015 CHANGED FOR 0.9189 DIMENSION 0.008" ADDED DIMENSION 1.015 CHANGED FOR 0.9189 ITEM -5 ENGINDED SIN AND "MADE IN USA" REMOVED, MATERIAL 6061-T6 CHANGED FOR 6061-T6/7075-T6, DIMENSION ϕ 8.65 CHANGED FOR ϕ 8.4768.467	VM	17-706
DESIGN	VM	VM	BY
DRAWN	VM	VM	
CHECKED	VM	VM	
MFG. APPR.	KFT		
APPROVED	JFC		
DATE	2019-06-27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B	
TOOL PART #		SHEET 1 OF 4	
RBT400228M		SCALE	
TITLE		NTS	
MAST NUT PSE			

1 2 3 4 5 6 7 8



RBT400228M-3 CYLINDER

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8925 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = ± 0.1 / ± 1
X.XX = ± 0.01 / ± 0.5
X.XXX = ± 0.005 / ± 0.1
X.XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT400228M", AS SHOWN